Work Order ID 64694

Tuesday, December 14, 2010 1:09:42 PM

Item ID: D120-638-011 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Bearpaw

Start Date: 12/14/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 12/22/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** RL **Date:** 10/2/14 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2435	Rev E1								
100		0.00							
DC	DOCUMENT CONTROL								
Document Control	**Memo**	0.00							
	Photocopy bluefile and create labels per PPP D120-638-011 CHG 002		5/1/07						
160	Pick Kit	0.00							
Packaging									
Packaging	**Memo**	0.00							
170	QC4- 100% Inspect kits for completeness	0.00							
QC									
Quality Control	**Memo**	0.00							

CK 11/01/06

11/1/06 SP 20

5/1/07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPPD120-638-011 Location: 113 REWA								
190	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/01/07 (2) 28

CK 11/01/07

MF 11-01-07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Picklist Print

Tuesday, December 14, 2010 1:09:46 PM

Work Order ID: 64694

Parent Item: D120-638-011

Parent Item Name: Bearpaw

Start Date: 12/14/2010 **Required Date:** 12/22/2010

Start Qty: 2.00 **Required Qty:** 2.00

Comments:
IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B Added Step 2 08-04-16 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2435 Bearpaw, 206		Manufactured	No			160	Each	0.0000	2	4	64692	12/11/2006	
D2182B050 Clamp Cushion Black		Manufactured	No			160	Each	6.0000	4	8	B63413	11/1/6	
D2274 Radius Block		Manufactured	No			160	Each	25.0000	8	16	B64420	11/1/6	
D2438 Clamp		Manufactured	No			160	Each	3.0000	4	8	B63999	11/1/6	

D2435 Bearpaw, 206 — 5 ft

D2182B050 Clamp Cushion Black — 5 ft

x4 @ 5.0" ! → measured 5/1/01/07

3 feet 4" inches

Location	Loc Qty	Loc Code
ST402	6	
63470	6	

D2274 Radius Block — 5 ft

Location	Loc Qty	Loc Code
ST010	25	
61361	1	
63990	24	

D2438 Clamp — 5 ft

Location	Loc Qty	Loc Code
ST456	3	
60852	3	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Picklist Print

Tuesday, December 14, 2010 1:09:46 PM

3

Work Order ID: 64694

Parent Item: D120-638-011

Parent Item Name: Bearpaw

Start Date: 12/ .4/2010 **Required Date:** 12/22/2010

Start Qty: 2.00 **Required Qty:** 2.00

D2529 Washer	Manufactured	No	160	Each	927.0000	8	16	11/1/6 SP

Location		Loc Qty	Loc Code	
ST017		927		
	64127	927		10

AN4-15A Bolt	Purchased	No	160	Each	203.0000	8	16	11/1/6 SP

Location		Loc Qty	Loc Code	
ST358		203		
	114784	9		
	115108	5		
	115371	5		
	115936	184		16

AN960JD416 NAS1149D0463J Washer	Purchased	No	160	Each	30.0000	8	16	M116289 11/1/6 SP

Location		Loc Qty	Loc Code	
ST300		24		
	113288	24		
ST356		6		
	115622	6		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Picklist Print

Tuesday, December 14, 2010 1:09:46 PM

3

Work Order ID: 64694

Parent Item: D120-638-011

Parent Item Name: Bearpaw

Start Date: 12/14/2010 **Required Date:** 12/22/2010

Start Qty: 2.00 **Required Qty:** 2.00

MS21042L4	Purchased	No	160	Each	4,634.000	8	16	
Nut								

Location	Loc Qty	Loc Code
ST300	4634	
1123143	2	
115589	32	
115621	1100	16
116188	3500	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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REFERENCE ONLY

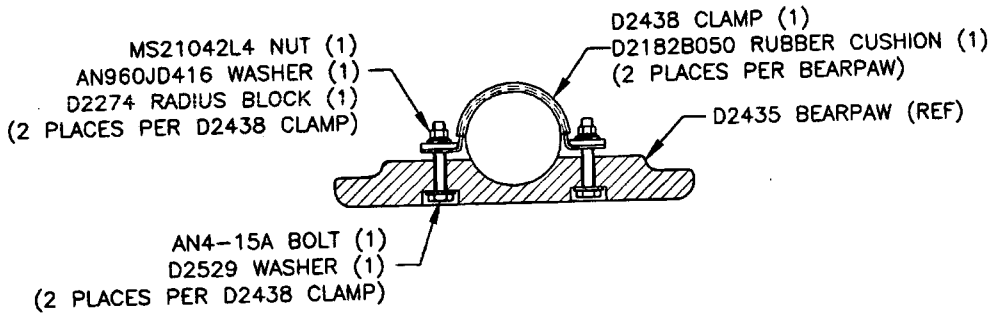

Figure 2 – Bearpaw Installation

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-638-011 Bearpaw	8.4 lb 3.82 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.7 in 4.54 m	1501.1 in-lb 17.34 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	**D120-638-011**	**BEARPAW INSTALLATION**
4	D2182B050	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2435	Bearpaw
4	D2438	Clamp
8	AN4-15A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)